

Welding and Brazing Final Visual Examination Checklist

(See [ES&H Manual Welding and Brazing Program Supplement](#) for more information.)

FINAL VISUAL EXAMINATION – INFORMATION

Group: SRF (PPU) Group		Component: RUPTURE DISK SPOOL ASSEMBLY S/N-004		Date: 8/26/22
Drawing #: 104210200-M8U-8200-A061		Rev#:	PQR #: On File	WPS/BPS #: On File
Welder/Brazer #: Vendors Welder On File		Process: GTAW		B31.3 Fluid Service: Normal
ACCEPTANCE CRITERIA	☒ ASME B31.3 Chapter VI [Table 341.3.2]	☐ AWS D1.1 Chapter VI [Table 6.1]	☐ Other Code(s):	
# of Welds or Brazes Examined: ALL WELDS ON THIS ASSEMBLY (S/N-004)		# of Mechanical Joints Examined: N/A		

FINAL VISUAL EXAMINATION – CHECKLIST

	Accept	Reject	N/A
1. Mechanical joints have been properly assembled	☐	☐	☒
2. Mechanical joints have been properly erected including alignment supports and cold spring	☐	☐	☒
3. Welds/Brazes were sufficiently cleaned as not to impair visual inspection and are uniquely identified	☒	☐	☐
4. Geometry or profile conforms to WPS/BPS, drawing details or Code requirements	☒	☐	☐
5. Weld joint was properly identified to welder/brazer	☒	☐	☐
6. All flux/slag removed	☒	☐	☐
WELDING ONLY:			
7. Weld has no visible cracks	☒	☐	☐
8. Thorough fusion (weld and base metals) and complete penetration if required exist	☒	☐	☐
9. Surface porosity or exposed slag inclusion	☒	☐	☐
10. Surface finish	☒	☐	☐
11. Concave root surface (suck up) or lack of weld joint break down	☒	☐	☐
12. Internal and external reinforcement within allowable limits	☒	☐	☐
13. Any fillet weld undersize(AWS only) within limits and undercutting depths	☒	☐	☐

REMARKS:

SIGNATURE

Jenord Alston



Jenord Alston
CWI 09111931
QC1 EXP. 11/1/2024

DATE 8/26/22

EXAMINER / INSPECTOR

ISSUING AUTHORITY	TECHNICAL POINT-OF-CONTACT	APPROVAL DATE	REVIEW DATE	REV.	Page
ESH&Q Division	Jenord Alston	02/06/2017	02/06/2022	1.1	1 of 2

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Jefferson Lab
CM 08111931
QCI EXP. 11/1/2024

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Form Signed

Person: Martha Calkins (mcalkins@jlab.org) ORIG: FMLP		Status: Pending Approval Date: 03/14/2022 09:43 AM	
JSA THOMAS JEFFERSON NATIONAL ACCELERATOR FACILITY 12000 Jefferson Avenue Newport News, VA 23606 Phone: (757) 269-7100			
PO Inspection 128216			
PO #*	Vendor*	View PO #22-M0065 New Return To Vendor Form for this PO At PO #22-M0065 Return Vendor Forms	
22-M0065	RAY INSTRUMENTS LLC (RAYINS)		
Procurement Officer*	Deliver To		
PRM CHARLIE Y (070632)	C KIM MIKE DICKEY		
Inspection Type	SRL Rec #	Click here to open in SRL application	
welding	402950		
Inspector		Recipient: SDTR	
Inspector	Designee (if needed)	Recipient*	Designee (if needed)
Jefferson Alston (jaston)		Mike Dickey (mdickey)	
Inspector Disposition		Disposition	
☐ Accepted ☒ Rejected ☐ Partially Accept ☐ Not Applicable		☐ Accepted ☐ Rejected ☐ Partially Accept	
Inspector Disposition Comments		Disposition Comments	
The selected vendor is not on the JLab AVL. I have none of the code required welding related documentation for this component			
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104210200-MBU-8200-A060.pdf Delete Attachment			
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Deliver Authorized Signers			
To/Designee Mike Dickey (mdickey@jlab.org)			
Inspector Signed By: Jefferson Alston (jaston@jlab.org) on 03/14/2022 09:44:20 AM Un-Sign			
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 Jenord Alston
CWI 09/11/931
QC1 EXP. 11/1/2024



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HOLD - INSPECTION PENDING
RUPTURE DISC SPOOL ADAPTER
PN: 104210200-M8U-8200-A061
SN: 004

TID: 66871

Project: SNSPPU
P.O. 20-D0688



Rev: -

ACCEPTED

CUSTOMER SNS

W.O. NO. _____ DATE 8-26-22
NO. PCS. _____ MATERIAL _____
PART NO. _____ SER. NO. 004
PART NAME Rupture Disc Spool Adapter Assy
INSPECTOR E. Mosby
COMMENTS Visual & Dimensional

